

Work Order ID 50310

July 14, 2009 11:53:24 AM



Page 1

Item ID: D3697-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Tube Assembly

Start Date: 7/15/09

Start Qty: ~~1.00~~ 2



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: ~~1.00~~



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3697	Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- cut at 6.00" as per dwg D3697 2- form and trim tube as per dwg D3697 using DT9003 3-deburr

EL 9-7-22

X7

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 809/07/02

(+2)

f

120

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-weld D3697-3/-4 and D3797-1 on tube D3697-1 as per dwg D3697 using DT9003 welding jig □ 2-drill holes in tube in 5 pls as per dwg D3697

BE 9-7-22 x2

140

0.00



QC9- Inspect visual per QS1004- Fusion Welds

QC

Memo

0.00

Quality Control

BE 9-7-22 x2

150

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

⇒ 5014/03

⑫ 6

Dart Aerospace Ltd

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Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160 Chemical Conversion Coat per QS1005 4.1 0.00



HandFinish

Memo

0.00

Hand Finishing

2X m-l 09/07/22

170 QC3- Inspect Part Finish 0.00



QC

Memo

0.00

Quality Control

2 BK 09-07-22

180 Identify as per dwg & Stock Location 241A 0.00



Packaging

Memo

0.00

Packaging

9/7/22 2X SP

W/O:		WORK ORDER CHANGES					
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Stop



Item Name: Tube Assembly

Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/23

ME
09-07-22

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 50310

Parent Item: D3697-041RevB

Parent Item Name: Tube Assembly



Comments:

Start Date: 7/15/09

Required Date: 7/15/09



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3697-3RevB		Manufactured	No			130	Each	2.0000	1.0000			
												
Support Plate, LH												



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
41024	2	

2 EL

D3697-4RevB		Manufactured	No			100	Each	4.0000	1.0000			
												
Support Plate, RH												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	4	
41025	4	

2 EL

D3797-1RevB		Manufactured	No			130	Each	6.0000	1.0000			
												
Ground Plate												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
40688	3	
41023	1	
46321	2	

1 EL

9-7-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 50310



Parent Item: D3697-041RevB



Parent Item Name: Tube Assembly

Start Date: 7/15/09

Required Date: 7/15/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T0.375W.049		Purchased	No			130	f	108.0000	6.3158			



6061-T6 RD Tube .375 x.049W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

109000

108

108

~~30~~ 30'

9-7-22

July 14, 2009 11:53:23 AM

Shop Packet Print

Page 2

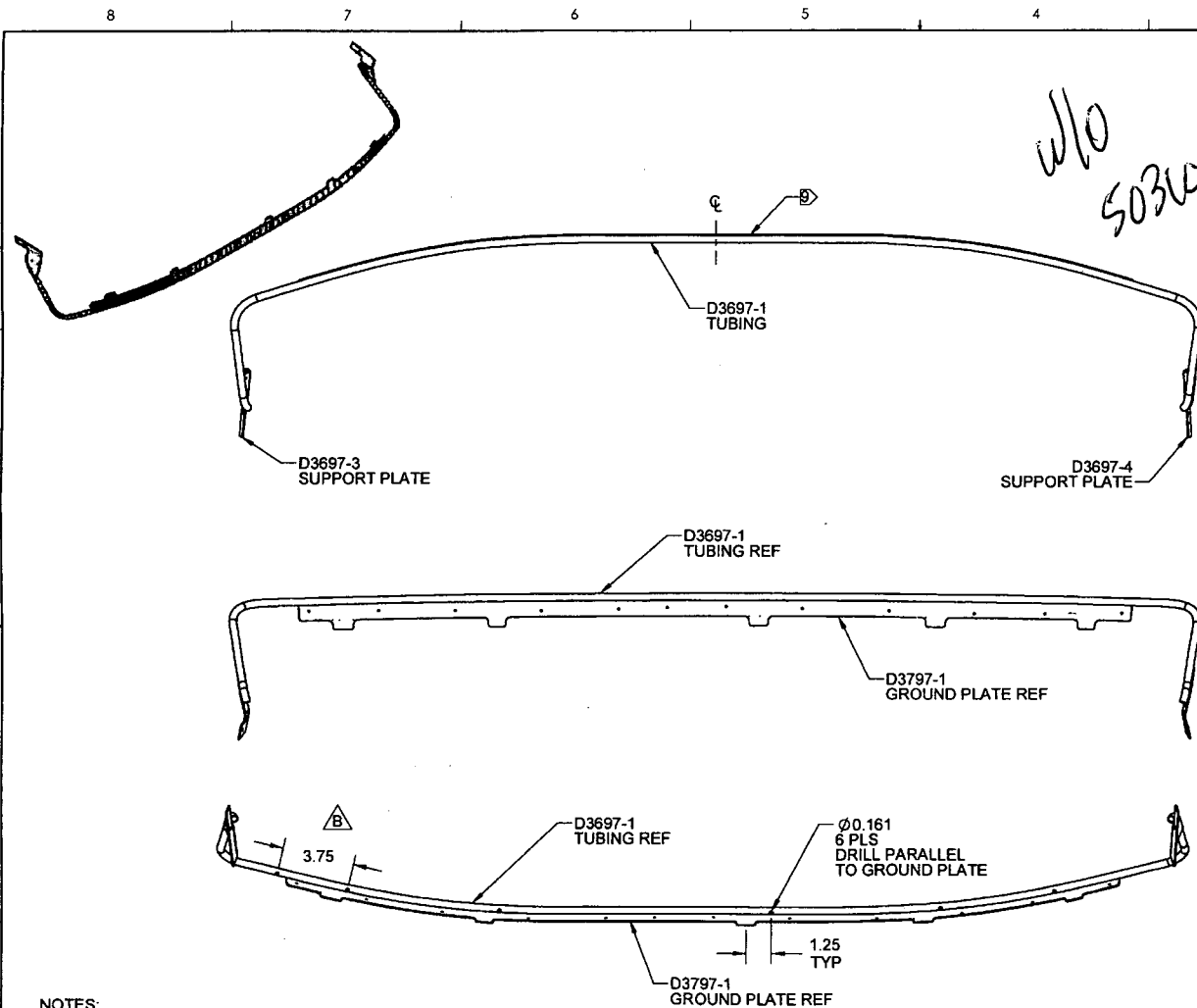
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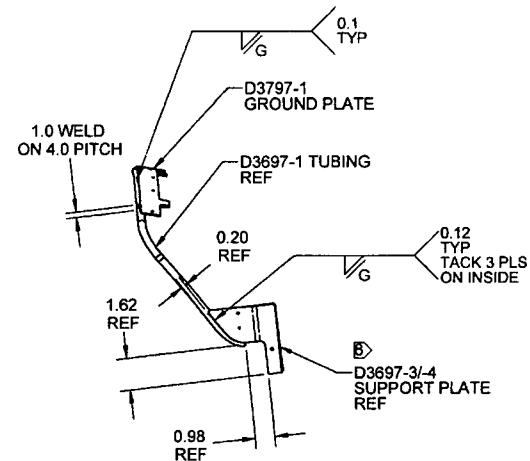
NOTE: Date & initial all entries



NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.55 lbs
- 8) LOCATE D3697-3/4 ON D3697-1 USING DT9009 WELDING JIG
- 9) CENTER D3797-1 GROUND PLATE ON D3697-1 TUBING

D3697-041 TUBE ASSEMBLY



PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3697-041	TUBE ASSEMBLY
1	D3697-1	TUBING
1	D3697-3	SUPPORT PLATE
1	D3697-4	SUPPORT PLATE
1	D3797-1	GROUND PLATE

B	REMOVE POWDER COAT & MASKED HATCHED AREAS. SHEET 1 ZONE A,8; ADD Ø0.161 HOLE. SHEET 1 ZONE B,7	RF	08.06.02
A	NEW ISSUE	RF	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	08.06.02		

RELEASED
08-07-02

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3697** REV. B
SHEET 1 OF 3
TITLE **TUBE ASSEMBLY** SCALE NTS

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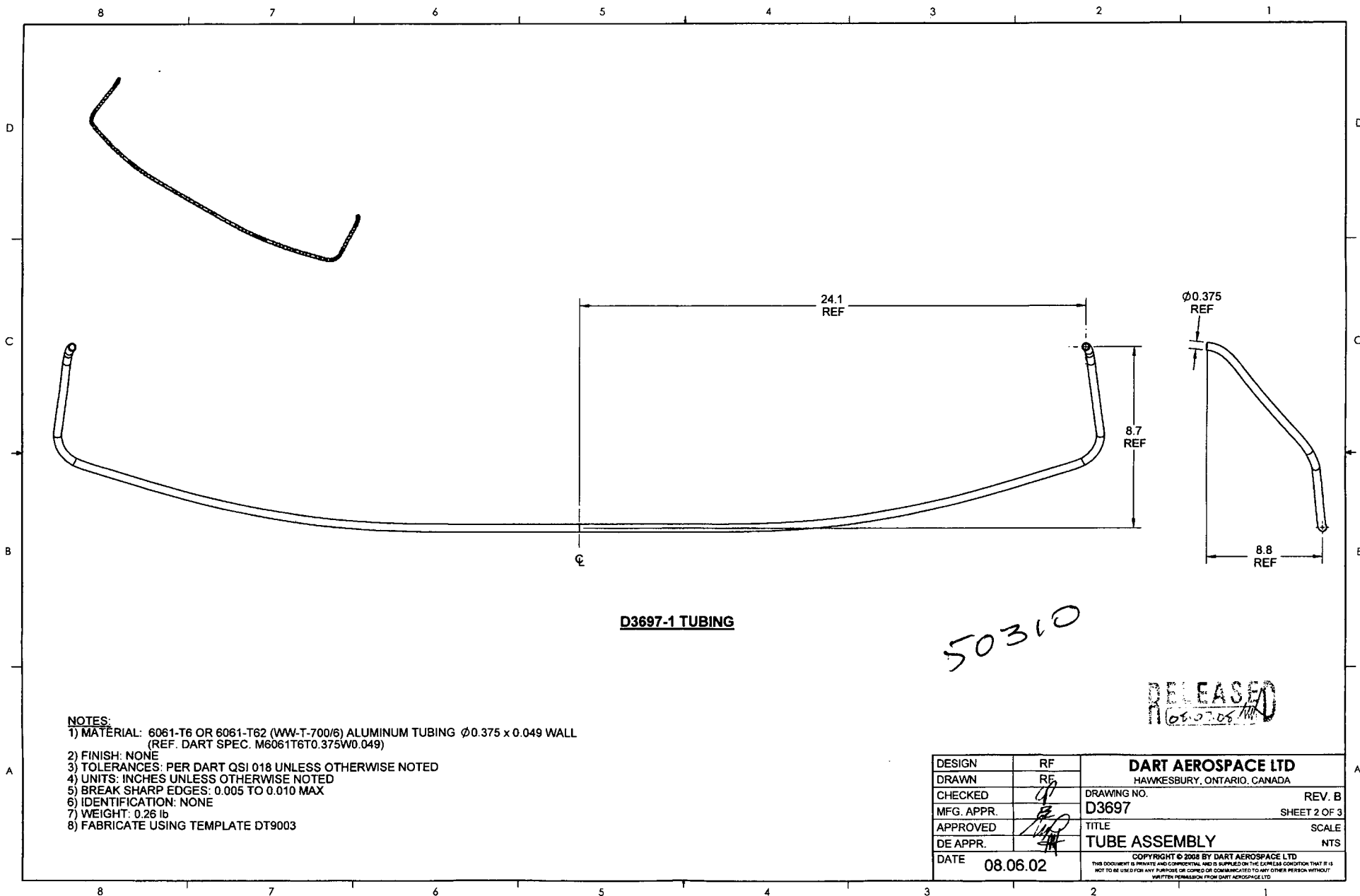
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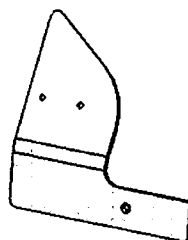
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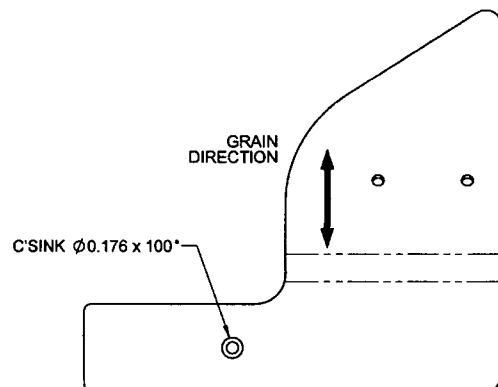
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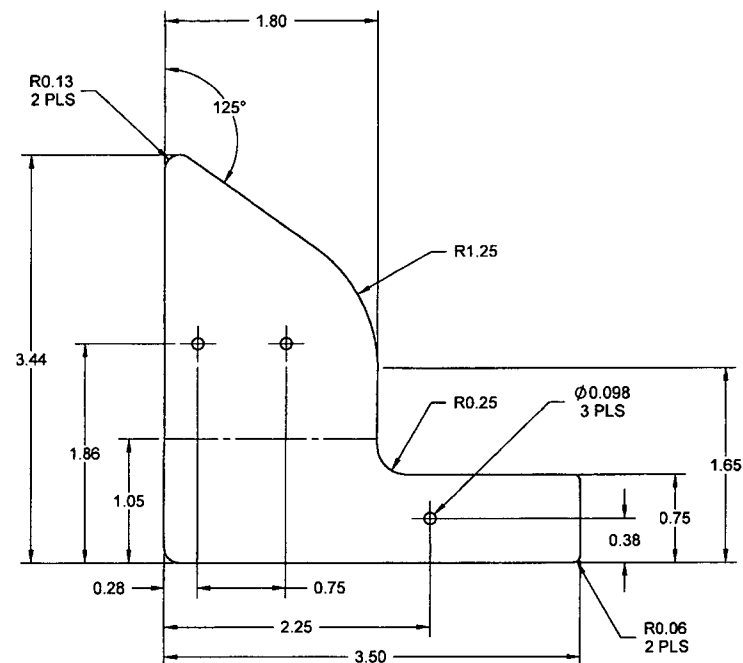
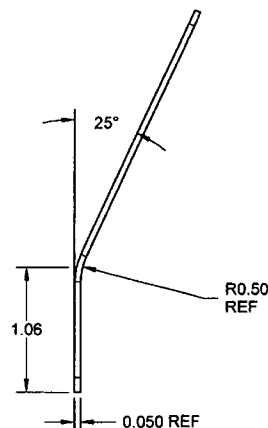
D3697-3 SUPPORT PLATE (LH SHOWN)



D3697-4 SUPPORT PLATE (RH SHOWN)



**D3697-3 SUPPORT PLATE (LH SHOWN)
(D3697-4 SUPPORT PLATE OPPOSITE)
(MAKE FROM D3697-3F FLAT PATTERN)**






D3697-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.050 THICK (REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

50310

RELEASED
08-07-02

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3697	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		TUBE ASSEMBLY	NTS
DATE	08.06.02	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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